

Title (en)  
METHOD FOR THE PRODUCTION OF CONTAINERS

Title (de)  
VERFAHREN ZUR HERSTELLUNG VON BEHÄLTERN

Title (fr)  
PROCÉDÉ DE FABRICATION DE RÉCIPIENTS

Publication  
**EP 4000860 B1 20221214 (DE)**

Application  
**EP 21200896 A 20211005**

Priority  
DE 102020129996 A 20201113

Abstract (en)  
[origin: CA3136963A1] The method of manufacturing containers consisting of a substantially stiff outer container and a readily deformable inner bag of first and second thermoplastic plastic materials, which do not form a weld connection with one another, wherein a first thermoplastic plastic material for the outer container is supplied to a first screw conveyor and the second thermoplastic plastic material for the inner bag is supplied to a second screw conveyor, which are connected to an extruder nozzle, which coextrudes a preform consisting of two tubes, which is arranged between the open halves of a blow mould, wherein the blow mould is closed when the preform has the length necessary for the manufacture of the container, wherein excess material in the base material of the container to be manufactured is squeezed out and a web is formed from material of the outer container, in which the welded base seam of the inner bag can be clamped and held in the axial direction, and wherein the preform is inflated by a pressure medium into engagement with the wall of the blow mould and is removed from the blow mould and whereafter the inner bag is detached from the wall of the outer container is characterised in that the excess material is supplied again to the first screw conveyor, which mixes the excess material with the first thermoplastic plastic material and supplies it to the extruder nozzle, wherein the first thermoplastic plastic material has a lower viscosity in the molten state than the excess material so that the outer layer of the extruded tube consists only of the first thermoplastic plastic material.

IPC 8 full level  
**B29C 48/00** (2019.01); **B29B 17/00** (2006.01); **B29B 17/04** (2006.01); **B29C 48/09** (2019.01); **B29C 48/10** (2019.01); **B29C 48/16** (2019.01); **B29C 48/275** (2019.01); **B29C 48/335** (2019.01); **B29C 49/02** (2006.01); **B29C 49/04** (2006.01); **B32B 27/08** (2006.01); **C08J 11/04** (2006.01); **B29K 23/00** (2006.01); **B29K 67/00** (2006.01); **B29K 77/00** (2006.01)

CPC (source: BR CN EP US)  
**B29B 17/0005** (2013.01 - EP); **B29B 17/0026** (2013.01 - EP); **B29C 45/14622** (2013.01 - BR); **B29C 45/14754** (2013.01 - BR); **B29C 45/1676** (2013.01 - BR); **B29C 45/261** (2013.01 - BR); **B29C 48/09** (2019.02 - CN); **B29C 48/21** (2019.02 - CN); **B29C 48/277** (2019.02 - CN EP); **B29C 48/49** (2019.02 - CN); **B29C 49/02** (2013.01 - EP US); **B29C 49/04** (2013.01 - CN EP US); **B29C 49/22** (2013.01 - US); **B29C 49/42** (2013.01 - US); **B32B 27/08** (2013.01 - EP); **B32B 27/306** (2013.01 - EP); **B32B 27/32** (2013.01 - EP); **B32B 27/34** (2013.01 - EP); **B32B 27/36** (2013.01 - EP); **B29B 17/04** (2013.01 - EP); **B29C 48/0015** (2019.02 - EP); **B29C 48/0017** (2019.02 - EP); **B29C 48/09** (2019.02 - EP); **B29C 48/21** (2019.02 - EP); **B29C 48/335** (2019.02 - EP); **B29C 49/04108** (2022.05 - EP); **B29C 2049/023** (2013.01 - EP); **B29C 2949/3088** (2022.05 - US); **B29K 2023/0633** (2013.01 - EP); **B29K 2023/065** (2013.01 - EP); **B29K 2023/12** (2013.01 - EP); **B29K 2067/003** (2013.01 - EP); **B29K 2077/00** (2013.01 - EP); **B29K 2101/12** (2013.01 - US); **B29L 2031/712** (2013.01 - BR US); **B32B 2250/24** (2013.01 - EP); **B32B 2307/536** (2013.01 - EP); **B32B 2439/00** (2013.01 - EP); **Y02P 70/10** (2015.11 - EP); **Y02W 30/62** (2015.05 - EP)

Designated contracting state (EPC)  
AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO RS SE SI SK SM TR

DOCDB simple family (publication)  
**DE 102020129996 B3 20220303**; BR 102021022709 A2 20220531; BR 102021022709 A8 20240312; CA 3136963 A1 20220513; CN 114474675 A 20220513; CN 114474675 B 20240308; EP 4000860 A1 20220525; EP 4000860 B1 20221214; MX 2021013957 A 20220516; US 2022152907 A1 20220519

DOCDB simple family (application)  
**DE 102020129996 A 20201113**; BR 102021022709 A 20211111; CA 3136963 A 20211029; CN 202111299065 A 20211104; EP 21200896 A 20211005; MX 2021013957 A 20211112; US 202117522043 A 20211109